

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023221**Date Inspected:** 27-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in the Bay 10:

FCAW repair welding of weld joints X3305K-038-001, 002; X3305K-025-001, 002 located on PCMK OBG splice plate channel. Welder was identified as 054069. QC was identified as ZPMC CWI Li Jun (QC1). Also at this location and appearing to be monitoring the welding operation and recording data was ABF CWI Yang Yi Heng (ABF1). Weld variables recorded by QC1 appeared to comply with WPS-345-FCAW-3G(3F)-ESAB-repair as displayed on ZPMC Weld Repair Report B-WR20842 as presented to this QA Inspector and verbally identified by QC1. See photo below of weld joints X3305K-038-001, 002 after repair welding.

SMAW repair welding of weld joints X3305K-037-001, 002 located on PCMK OBG splice plate channel. Welder was identified as 053829. QC was identified as QC1. Also at this location and appearing to be monitoring the welding operation and recording data was ABF1. Weld variables recorded by QC1 appeared to comply with WPS-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20842 as presented to this QA Inspector and verbally identified by QC1.

SMAW repair welding of weld joint X3305K-035-002 located on PCMK OBG splice plate channel. Welder was identified as 040581. QC was identified as QC1. Also at this location and appearing to be monitoring the welding

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operation and recording data was ABF1. Weld variables recorded by QC1 appeared to comply with WPS-345-SMAW-3G(3F)-repair as displayed on ZPMC Weld Repair Report B-WR20842 as presented to this QA Inspector and verbally identified by QC1.

Fit-up and SMAW tack welding of railing post support base and conduit support located on PCMK OBG BK014, bike path. Welder was identified as 061938. QC was identified as QC1. Weld variables recorded by QC1 appeared to comply with WPS-B-P-2212 as verbally identified by QC1. See photo below of ZPMC welder 061938 tack welding one of the railing post support bases to the bike path deck.

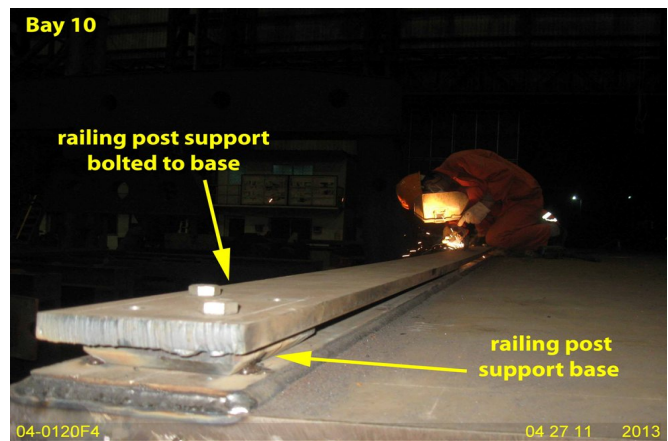
OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

SMAW welding of temporary alignment plates across the 13AW/13BW transverse joint, side plate, south (crossbeam) side, located on PCMK OBG Segments 13AW/13BW. Welder was identified as 045246. QC was identified as ABF CWI Ji Cai Fang (QC2). Assisting QC2 at this location and appearing to be monitoring the welding operation and recording data was ZPMC QC Wang Zhu (QCA2), who was not a CWI. Weld variables recorded by QCA2 appeared to comply with WPS-B-P-2114-FCM-1 as verbally identified by QCA2.

Heat straightening of BK017-001-015 and BK016-001-015 while mounted, respectively, on PCMK OBG Segment 12CE at panel point 117 and Segment 12BE at panel point 115. BK016 had a 5 ton weight positioned at the outside end. QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the heat treating operation and recording data was QCA2, who was not a CWI. Heat treatment variables recorded by QC2 appeared to comply with ZPMC document HSR1(B)-10301 as presented to this QA Inspector and verbally identified by QCA2.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As noted above.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
